

Work Order ID 111630

\*111630\*

Page 1

January-16-14 8:30:37 AM

Item ID: D2432 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Bearpaw 19" X 24"

Start Date: 1/16/14 Start Qty: 8.00 \*8\*

Required Date: 1/30/14 Req'd Qty: 8.00 \*8\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-01-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2432	H
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120

\*120\*

FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

9

0

Jm 14-02-15

130

\*130\*

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

14-02-28/

9

0

MH 14/03/03

140

\*140\*

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

14-02-28/

9

0

MH 14/03/03

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\*111630\*

Page 2

January-16-14 8:30:37 AM

Item ID: D2432

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw 19" X 24"

Start Date: 1/16/14

Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00

\*150\*

QC

Memo

0.00

Quality Control

9 14-3-12

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

\*160\*

Packaging

Memo

Packaging

0.00

PPP 103023  
106875

14/3/17 (9) DAS 32 9-89

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

Quality Control

0.00

14-03-18

14-03-17

# Picklist Print

January-16-14 8:30:40 AM

Page 1

Work Order ID: 111630

**\*111630\***

Parent Item: D2432

**\*D2432\***

Parent Item Name: Bearpaw 19" X 24"

Start Date: 1/16/14

Required Date: 1/30/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

582.7082

3.7

30

**\*MUHMWB10\***

UHMW 1" Black - 48"x120"

Tivar Mfg.#52480104

**\*\***

*Jm 14-02-15*

Location

Loc Qty

Loc Code

MAT018

582.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

m126748

14

m127491

34

m127891

400

128011 ~~128011~~

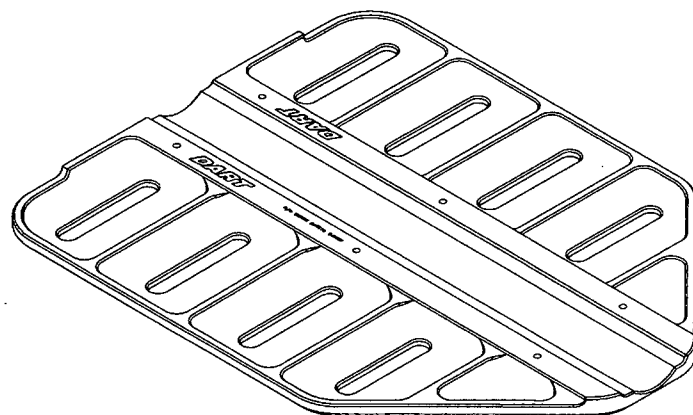
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 111630
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> H	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

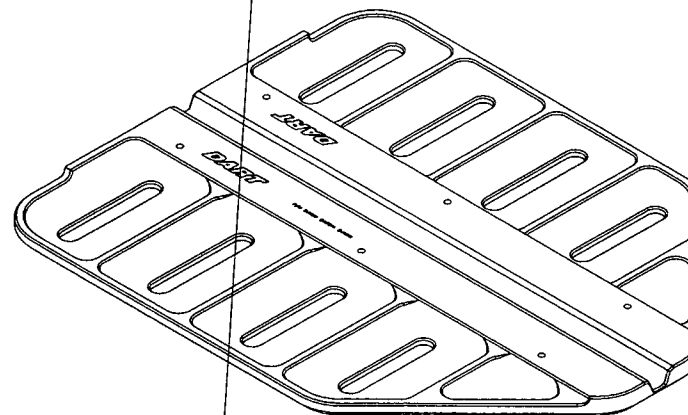
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063 x 45°	+0.030/-0.010	.063 x 45°	✓		SL08	Run
5.500	+/-0.030	5.501	✓			
0.200	+/-0.030	.195	✓			
0.25 x 45°	+/-0.030	.250 x 45°	✓			
R0.250	+/-0.030	R.250	✓		Rad gauge	
0.250	+/-0.010	.242	✓			
0.625	+/-0.030	.628	✓			
0.375	+/-0.010	.380	✓			
0.950	+0.030/0.010	.943	✓			
19.000	+/-0.030	19.000	✓		SL01	Tape
3.14	+/-0.030	3.140	✓			
3.28	+/-0.030	3.280	✓			
Ø0.260	+0.005/-0.000	.260	✓			
Ø0.93	+/-0.030	.930	✓			
0.30	+0.030/-0.000	.310	✓		SL11	depth gauge
23.750	+/-0.030	23.750	✓		SL01	Tape
4.250	+/-0.010	4.250	✓			
2.000	+/-0.030	1.997	✓			
9.000	+/-0.010	9.000	✓			
9.000	+/-0.010	9.000	✓			
0.375	+/-0.010	.375	✓			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 14-02-28	<b>Date:</b> 14-3-12	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ [Signature]	[Signature]



**D2432F BEARPAW**

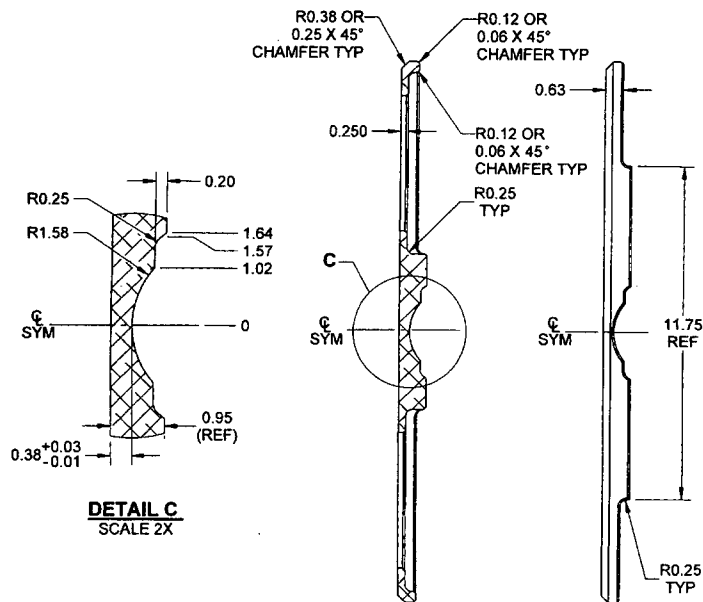


**D2432-3 BEARPAW**

111630  
MCS  
14-01-16

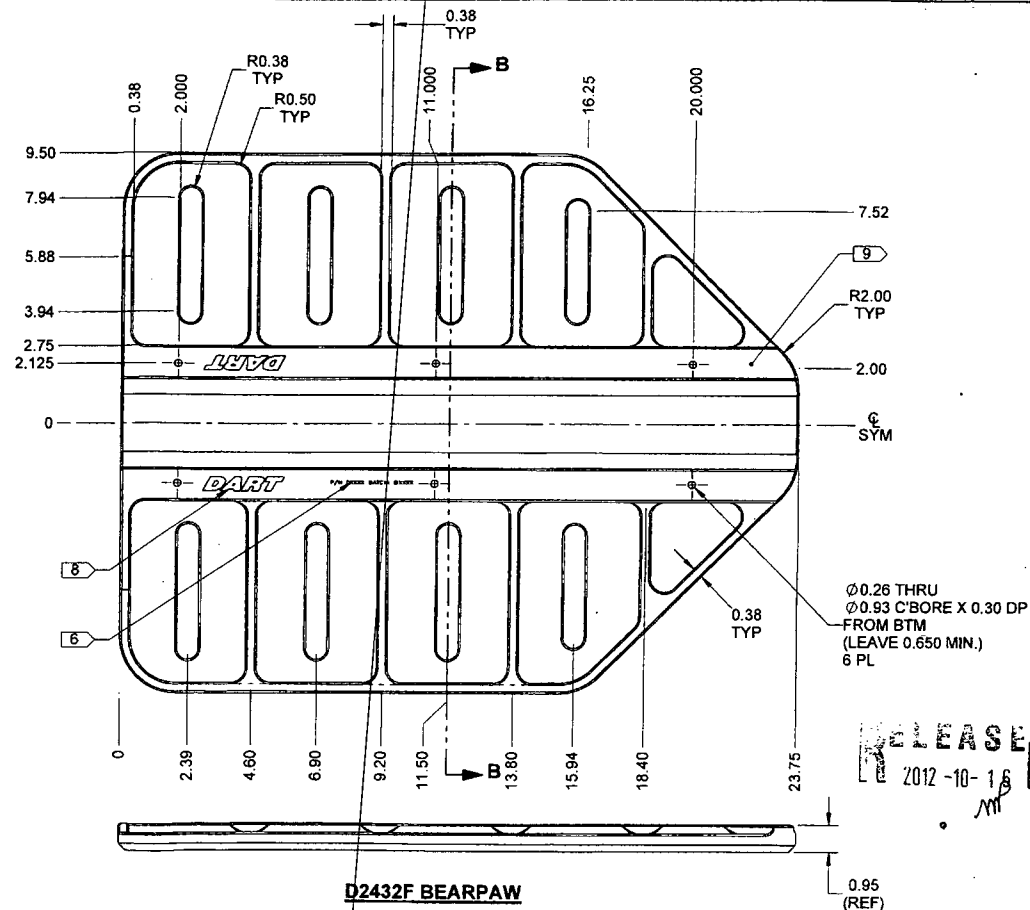
**RELEASED**  
2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	14	BEARPAW	NTS
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**DETAIL C**  
SCALE 2X

**SECTION B-B**



**D2432F BEARPAW**

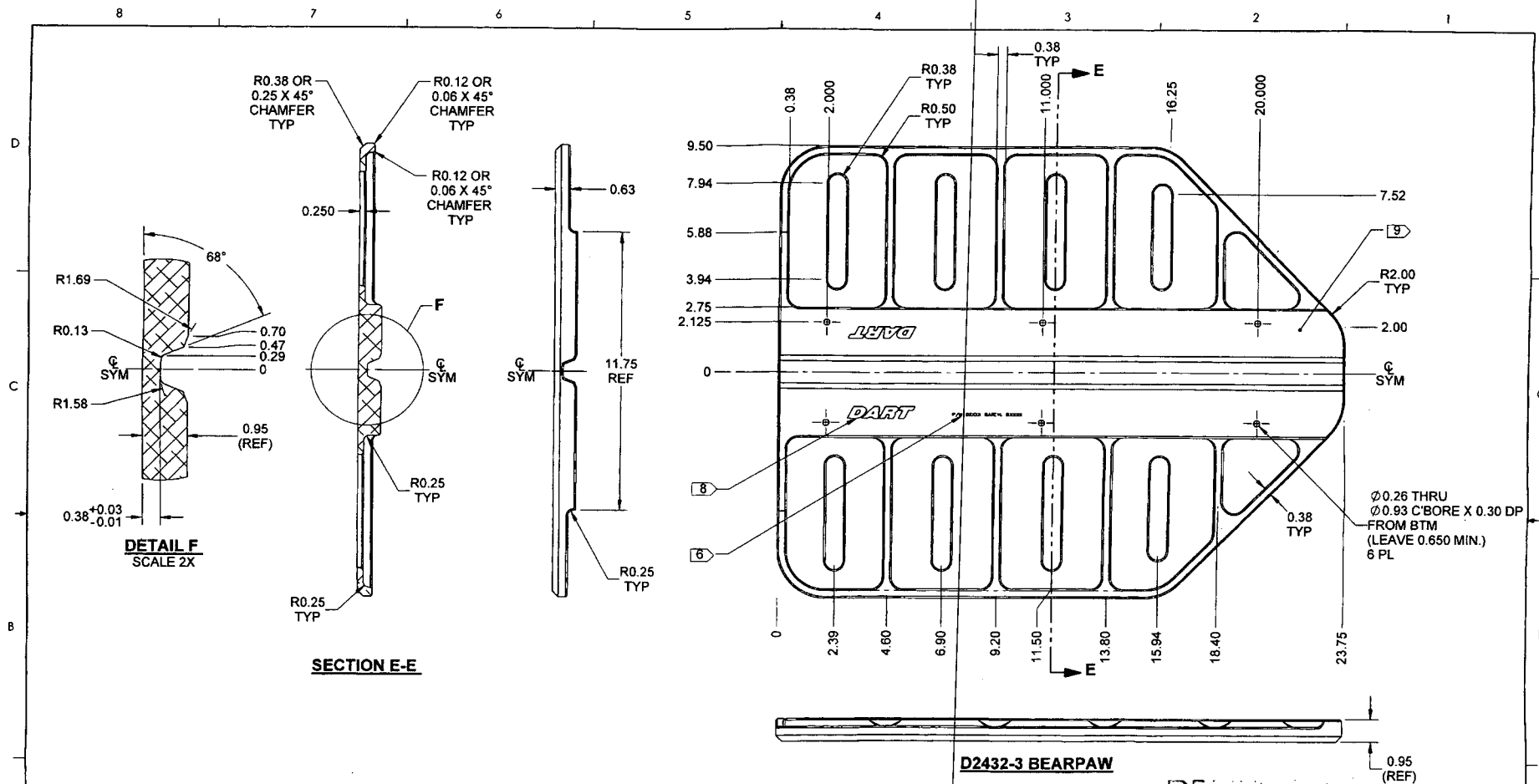
**NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	8/1	D2432	SHEET 2 OF 3
APPROVED	1/2	TITLE	SCALE
DE APPR.	#	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1985 BY DART AEROSPACE LTD	
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RELEASE  
2012-10-16





# NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 6.25 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	91	D2432	SHEET 3 OF 3
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	BEARPAW	NTS
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